Work Order ID Wednesday, October 12, 2		*74849*								Page 1
Item ID: D3183-0 Revision ID:			Accept	*N900040100)* s	Setup Star	17	S1*
Start Date: 10/12/20 Required Date: 10/12/20 Reference:	011 Start Qty: 20.00	*20* *20*		Cust Item ID: Customer:				Stop	' *N	S2*
Approvals: Process QC:	s Plan: MF	Date: - 10-12	Tooling: _ SPC (Y/N):	Date: Date:			F	Run Star Stop	" IX I	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						+			
D3183	Rev C1									
*100 *100* Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE S Memo Turn D3183-	SMALL 9 Cap as per Folio FA388E		100/11			20	<u>.</u>		
*110 *110* QC Quality Control	QC2- Inspect parts off ma	achine FAI/FAIB	0.00	(20			· :
120 *120* QC Quality Control	QC8- Inspect parts - second	nd check		010/11	حيا .	-	20			

Work Order ID 74849 Wednesday, October 12, 2011 9:04:17 AM				*74849*							Page 2
Revision ID:	D3183-045 Bearing Assen	nbly		Accept	*N9000)401	nr)* Setup	Start Stop	ı ı V.	S1* S2*
	10/12/2011	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ID: Customer:	:				"N:	\ /"
Approvals:	Process Pla	n:	Date:	Tooling: _ SPC (Y/N):	Date			Run	Start Stop	IMI	R1* R2*
Sequence ID/ Work Center II 130 *130 *130 *130 *nall Fab)	Operation Description Small Fab Memo Press D3183	3-5 Bearing into D3183-9 C	Set Up/ Run Hours 0.00 0.00 ap as per Dwg D3183.	Tool ID		Plan Code	Accept Re Qty Qt		Reject Number	Insp. Stamp
*140 *140* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00	B ulcoliz		(20			
150 *150* Packaging		Identify as per dwg & Sto	ock Location: <u>G B</u> WO 745	0.00 5-9 _{0.00}	So affo/12	_	(20)_	· · · · · ·		:

Packaging

Work Order ID 74849 Wednesday, October 12, 2011 9:04:18 AM				*74849*								Page 3
Item ID: D3183-045 Revision ID: Item Name: Bearing Assem		nbly		Accept	*N900040100		100	N* Setup		Start Stop	P. 1	S1* S2*
Start Date: Required Date: Reference:	10/12/2011 Start Qty: 20.00 10/12/2011 Req'd Qty: 20.00		*20* *20*		Cust Item ID: Customer:							
Approvals:	Process Plan:QC:		Date:	Tooling:	Date:		_	1	Run	Start	*N	R1*
			Date:	_ SPC (Y/N):			1		Stop	*NR2*		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
160		QC21- Final Inspection -	Work Order Release	0.00							$1 \cdot 1$	-1/Y
160 QC		Мето		0.00				<u> </u>			10	12

MF (1-10-12

Page 1

Work Order ID:

74849

Parent Item:

D3183-045

Parent Item Name:

Bearing Assembly

Start Date: 10/12/2011

Required Date: 10/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP A04.02.18New issueKJ/DS

****		en issuells, ps						•					
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5		Manufactured	No			110	Each	42.0000	1	- 20			
Bearing									- 	\$3 20 c	11.00/10		
				Location		Loc Oty	. <u>Lo</u>	c Code	1				
				ST236		42						*	
				675	29	1			-				
				737	97	1		,					•
				745	42	40			_2	2			. •
MDELRINR1.000		Purchased	No			130	f	32.1180	0.0333	0.701052	6		
Delrin Round Bar 1"					-					X	1010	///	
				Location		Loc Qty	Lo	c Code	:	•			
				MAT055		32.118			ĺ			a •	
				1179	985	0.407				Λ 1.			
				1182	257	18.002				Less			
				1183	392	13.709		_	5 - 1	···-			

DART AEROSPACE LTD	Work Order: 7	14849
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.830	+/-0.005	-831			9-62	
Ø0.720	+/-0.002	720				
Ø0.747	+/-0.001	, 247				
R0.010	+/-0.010	201				
R0.031	+/-0.010	R.031	///			
0.199	+/-0.001	1/99				
0.276	+/-0.010	-277				
0.039	+/-0.010	.040				
				Þ		
. ,						
		·				

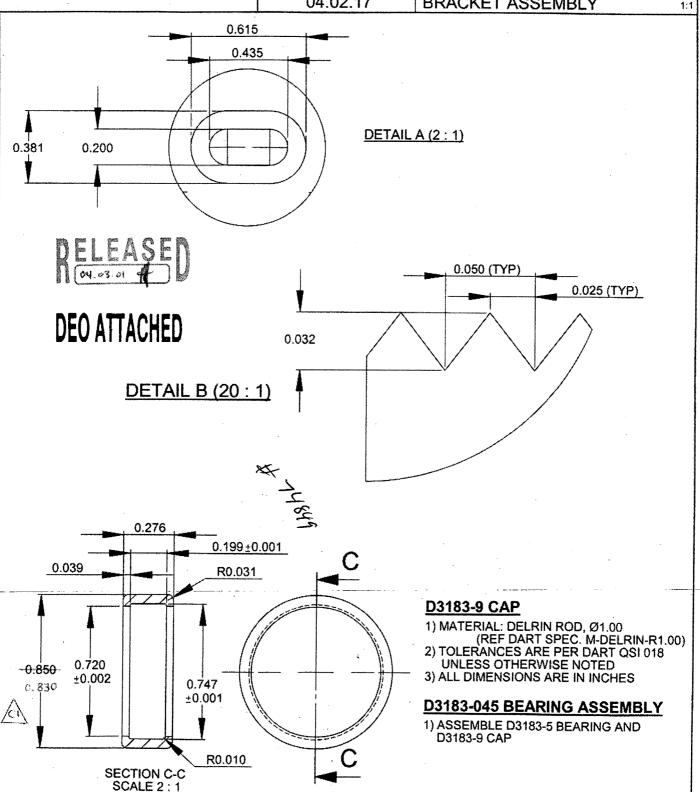
Measured by:	2		Audited by:	29	Prototype Approval:	N/A
Date:	1	10/11	Date:	11.00.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.20	New issue (P/O D3183-045)	KJ/RF	1
В	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM 🔏	ad





DESIGN /	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED	APPROVED	DRAWING NO.	REV. C SHEET 4 OF 4				
DATE 04.	02.17	BRACKET ASSEMBLY	SCALE 1:1				



COPYRIGHT @ 2003 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DRAWING		TITLE		, REV.C1		DART AER	OSPACE LTD	D.E.O.	NO.	SHEET	NO.	SCALE
D3183		BRACKET	ASSEMBLY	1.			RING ORDER		3-C1-1	SHEET		NTS
DRAWN	P		CHECKED	基	. 1	MFG. APPR.	$ oldsymbol{N} $	APPROVE	D M	DE APPR.	WL	
DATE	10.05.1	14	DATE	10.06.30	1		06.30	DATE	10/06/30		106/30	<u>:</u>

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT:

Cr = 1720 N (386 lb) MIN [DYNAMIC]

Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

6h8hL &



COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WINTETTER PERMISSION FROM DART AEROSPACE LTD.